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RBE703A94-1130-01

Job Sheet 188419



Part No: RBE703A94-1130-01

Job Qty: 6 ea

Part Name: Main Rotor Blade Trim Tab Tools Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/19

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *sfu*

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev A 17.10.27 New issue DP Verify DD/IPP Rev B 17.11.30 DWG
Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/31/19	1/31/19	0.00	0.00	Start Up Small Fab-2		<i>MLL</i>
110	Small Fab	6 pcs	1/31/19	1/31/19	0.00	6.00	Small Fab-3		<i>MLDAS</i>
120	QC	6 pcs	1/31/19	1/31/19	0.00	0.00	QC5		<i>38</i>
130	Packaging	6 pcs	1/31/19	1/31/19	0.00	0.00	Packaging3-1		<i>38</i>
140	QC21-FG	6 Ea	1/31/19	1/31/19	0.00	0.00	QC21		<i>38</i>

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

GA133

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	24 Ea (4 ea)	90-Start up Operation	<i>///</i>
APP-1450-E	Case	6 Ea (1 ea)	90-Start up Operation	<i>///</i>
RB41011	Dart Tooling Placard, Aluminum	6 Ea (1 ea)	90-Start up Operation	<i>///</i>
RBE703A94-1130-01-01	Immobilizing Clip Assembly	6 Ea (1 ea)	90-Start up Operation	<i>5135032</i>
RBE703A94-1130-01-23	Deflection Clip Assembly	6 Ea (1 ea)	90-Start up Operation	<i>5135 258</i>
RBE703A94-1130-01-47	Bottom Foam use in case APP-1450-E	6 pcs (1 ea)	90-Start up Operation	<i>///</i>
RBE703A94-1130-01-49	Top Foam use in case APP-1450-E	6 pcs (1 ea)	90-Start up Operation	<i>///</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	24	478	0
	APP-1450-E	6	18	0
	RB41011	6	494	0
	RBE703A94-1130-01-01	6	7	0
	RBE703A94-1130-01-23	6	12	0
	RBE703A94-1130-01-47	6	14	0
	RBE703A94-1130-01-49	6	14	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

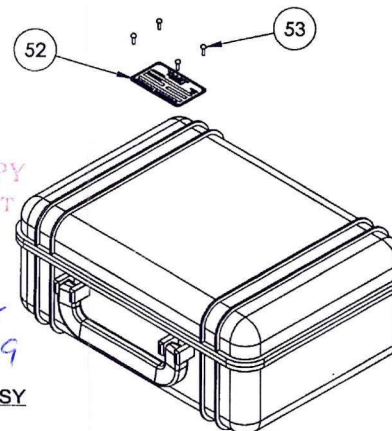
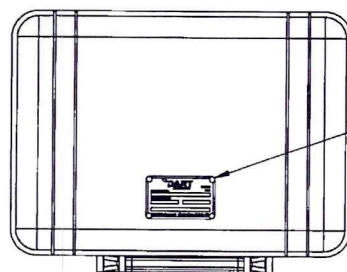
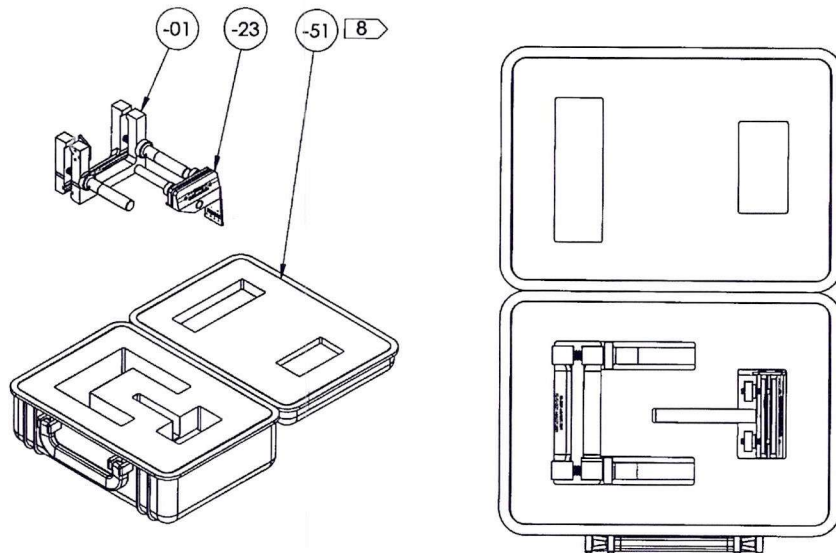
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

ITEM #	QTY	PART #	TITLE	PG
-01	1	RBE703A94-1130-01-01	IMMOBILIZING CLIP ASSY	2
-23	1	RBE703A94-1130-01-23	DEFLECTION CLIP ASSY	9
-51	1	RBE703A94-1130-01-51	PACKAGING ASSY	15
52	1	RB41011	DART PLACARD	-
53	4	McMaster#97524A032	RIVET 1/8" x 0.425" LG.	-

REV.	DESCRIPTION	DATE	BY	APPROVED
1	MOVED P/Ns -27, -29 FROM PAGE 3 TO 4. CHD ENGRAVE NOTE PIN -03. CHD HOLE DIA. PIN -25 & ADDED P.F. CHD DOWEL DIM TO METRIC ONLY. CHD PIN -27 ROLL PIN HOLE DIA. TO 4mm ONLY. ADDED P.F., CHD RADIUS DIM PIN -27. CHD DOWEL DIM TO 4mm ONLY. ADDED DEPTH .354. CHD RADIUS DIM -29.	5/1/2009	RJC	RW
1A	-49 ADDED LID FOAM.	4/13/2011	RJC	RW
2	CHD -03 & -09 NOTE 1 PER R.W. CHD -05 DOWEL PIN HOLE FROM Ø 1.18in. [30.3mm] PER G.E. -09 CHD C-DRILL FROM Ø4mm TO Ø 1.70 PER G.E. CHD -11 Ø 1.18 HOLE FROM P.F. TO S.F. PER G.E. CHD -21 FROM Ø3mm X 20mm PER R.W. ADDED -25 DIMENSION 1.250in. [32mm] TO ENSURE -25 WILL S.F. INTO -27 PER G.E. CORRECTED -27 & -29 CHAMFER DIMENSION FROM 1.97in. TO .197 PER G.E. ADDED -51 TO BOM. CHD -41 FROM DOWEL PIN.	9/16/2011	RJC	-
2A	ADDED -09 MISSING Ø3mm HOLE P.F. -19 DIMENSION. ADDED -27 MISSING R.062 DIMENSION PER G.E.	5/21/2012	RJC	GE
2B	CHD -03 & -09 FINISH FROM CLEAR ANODIZE TO RED ANODIZE, REMOVED POWDER COATING. NOTES. CHD -07 WAS #91310A555 STEEL TO #91287A165 S.S. CHD -47 WAS ROLL PIN TO DOWEL PIN.	4/17/2013	CFS	RW
3	-03, -09, -27 CHD ENGRAVE NOTE WAS RBE703A94-1130-01 IS RBE703A94-1130-01, -05 CORRECTED VIEWS. CHD DIM WAS Ø 3.15 1.25 IS Ø 3.15 1.25 S.F., CHD DIM WAS Ø 1.25 THRU IS Ø 1.25/1.25. 07 ADDED DIM S.F. -05. CHD DIM WAS Ø 1.25 FOR -21 IS Ø 1.25/1.25 THRU. -09 CHD DIM WAS Ø 1.18 P.F. -19 IS Ø 1.18/0.0075 (x2). -11 CHD DIM WAS Ø 1.18 S.F., -19 (x2) IS Ø 1.206/1.191 (x2). -25 CHD DIM WAS Ø4mm P.F. -41 IS Ø 1.575/1.572. CHD DIM WAS .625 S.F. -27 IS (1.625) S.F. -27. -27 CHD DIM WAS Ø4mm THRU S.F. -41 IS Ø 1.627/1.592 S.F. -41. CHD DIM WAS Ø4mm. 354 (x2) IS Ø 1.575/1.572 35 (x2) ADDED MISSING DIM .236. -31 CHD DIM WAS Ø 1.57 S.F. -41 (x2) IS Ø 1.607/1.592. ADDED MISSING DIM (1.394). -47 ADDED DIM (4X) R.37.	6/24/2013	BIM	RW
4	-35 CHD DIM WAS LIMITS Ø 1.572 TO .1575 IS LIMITS Ø 1.564 TO .1570. -27 CHD DIMS WAS Ø 1.592 TO .1607 IS Ø 1.575/1.580. WAS Ø 1.572 TO .1575 IS Ø 1.567/1.571. -31 CHD DIM WAS LIMITS Ø 1.592 TO .1607 IS Ø 1.578 TO .1585.	4/10/2014	DPD	GE
5	SEE ECR 16-0272	12/30/2016	RJC	SM
6	SEE ECR 17-0164	6/26/2017	RJC	JAG
K	SEE ECN 17 623, TEMPLATE UPDATE AS PER HAWKESBURY STANDARDS, -07 MATERIAL CHANGE FROM M8 SCREW TO M304R AND TOLERANCE .315/306 CHANGE TO .307 +.003/-0.003 AND THREAD CLASS ADDED, -05 TOLERANCE .315/316 CHANGE TO .309 +.003/-0, ASSY -51 ADDED. RIVETS AND EMPLACEMENT OF THE PLACARD ON THE PELICAN CASE ADDED	11/20/2017	VM	WM



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188419
MCS
190109

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE P/N & S/N WHERE INDICATED ON DART PLACARD (ITEM 52) BEFORE INSTALLATION ON THE PELICAN CASE (ITEM 45)
- 7) CENTER DART PLACARD (ITEM 52) IN AVAILABLE AREA OF THE PELICAN CASE'S LID (ITEM 45)
- 8) HOT GLUE TOP AND BOTTOM FOAM (ITEM -47 & -49) INTO THE PELICAN CASE (ITEM 45) AFTER DART PLACARD'S (ITEM 52) INSTALLATION
- 9) OEM P/N: E-703494-1130-01

DART AEROSPACE Hawkesbury, Ontario, Canada		TITLE	
		MAIN ROTOR BLADE TRIM TAB TOOLS ASSY	
DWD NO.		REV	
RBE703A94-1130-01		K	
DESIGN BY:	VM 9/11/2017	XXX ± .005	FRACTIONS & 1/8
DRAWN BY:	VM 11/24/2017	.XX ± .01	ANGLES & 1/2
CHECKED:	WM 11/30/2017	X ± .1	SURFACES = 125
MFG. APPR:	DP 11/30/2017	1. DIMENSIONS ARE IN INCHES	
APPROVED:	WM 11/30/2017	UNLESS OTHERWISE SPECIFIED	
DATE:	11/24/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE:	NTS	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
WEIGHT:	N/A	SHEET 1 OF 17	
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Container No: S144811



Part: FBE703A94-1130-01

Job No: 188419

Serial No/Batch: S144811

Revision: K

Inspector:

Exp Date:

Instructions:

Date: 01/15/19